



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4980-1**Job Sheet 204055****Part No:** D4980-1**Job Qty:** 10 pcs**Part Name:** Doubler**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 12/2/19**Job Tracking No:****Due Date:** 1/10/20**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG D4980 REV.C IPP REV:A 13.11.18 NEW ISSUE DD VERF:JLM IPP REV:B 14.06.16 AS PER DWG
REV.C DD VERF:JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
110	Waterjet - Flow - 1	10 pcs	1/10/20	1/10/20	0.17	0.25	Waterjet - Flow	m19/12/19
120	QC 2	10 pcs	1/10/20	1/10/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	m19/12/19
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	

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130	QC 8	10 pcs	1/10/20	0.00	0.00	QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
140	Outsource - 4 - Anodize	10 pcs	1/10/20			ATG001-VC	5
150	Packaging 2-1 - Receive - B4B	10 pcs	1/10/20	0.00	0.00	Packaging 2 - 1 - B4B	
						Packaging 2 - 2 - B4B	
						Packaging 2 - 3 - B4B	
						Packaging 2 - 5 - B4B	
						Packaging 2 - 4 - B4B	
						Packaging 2 - 6 - B4B	
						Packaging 2 - 7 - B4B	
						Packaging 2 - 8 - B4B	
						Packaging 2 - 9 - B4B	
						Packaging 2 - 10 - B4B	
						Packaging 2 - 11 - B4B	
						Packaging 2 - 12 - B4B	
						Packaging 2 - 13 - B4B	
						Packaging 2 - 14 - B4B	
						Packaging 2 - 15 - B4B	
						Packaging 2 - 16 - B4B	
						Packaging 2 - 17 - B4B	
						Packaging 2 - 18 - B4B	
						Packaging 2 - 19 - B4B	
						Packaging 2 - 20 - B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	

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					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
160 QC 5	10 pcs	1/10/20	0.00	0.00	QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
190 Packaging 3-1 - Stock - B4B	10 pcs	1/10/20	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	

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				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200 QC 21 - SA	10 pcs	1/10/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	8-09

Part Op 110 - 1-Cut as per Dwg Dwg Rev: C Prog Rev: C 2-Deburr if necessary

Descriptions: 120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Issue P/O to ATG : 45491 AS PER DWG D4980 1- HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, 2- PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005 Certification of Conformity is required

150 - Receive & Inspect for Damage & Mat'l Certs

160 - QC5- Inspect part completeness to step on W/O

190 - Identify as per dwg & Stock Location: _____ ***IDENTIFY WITH DART PIN "D4980-1", REVISION, BATCH NUMBER AND DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2***

200 - QC21- Final Inspection - Work Order Release

JAN 16 2020

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M7075T6S.125	7075-T6 Sheet .125	.1640 sf (.0164 ea)	110-Waterjet - Flow - 1	FM 1216309

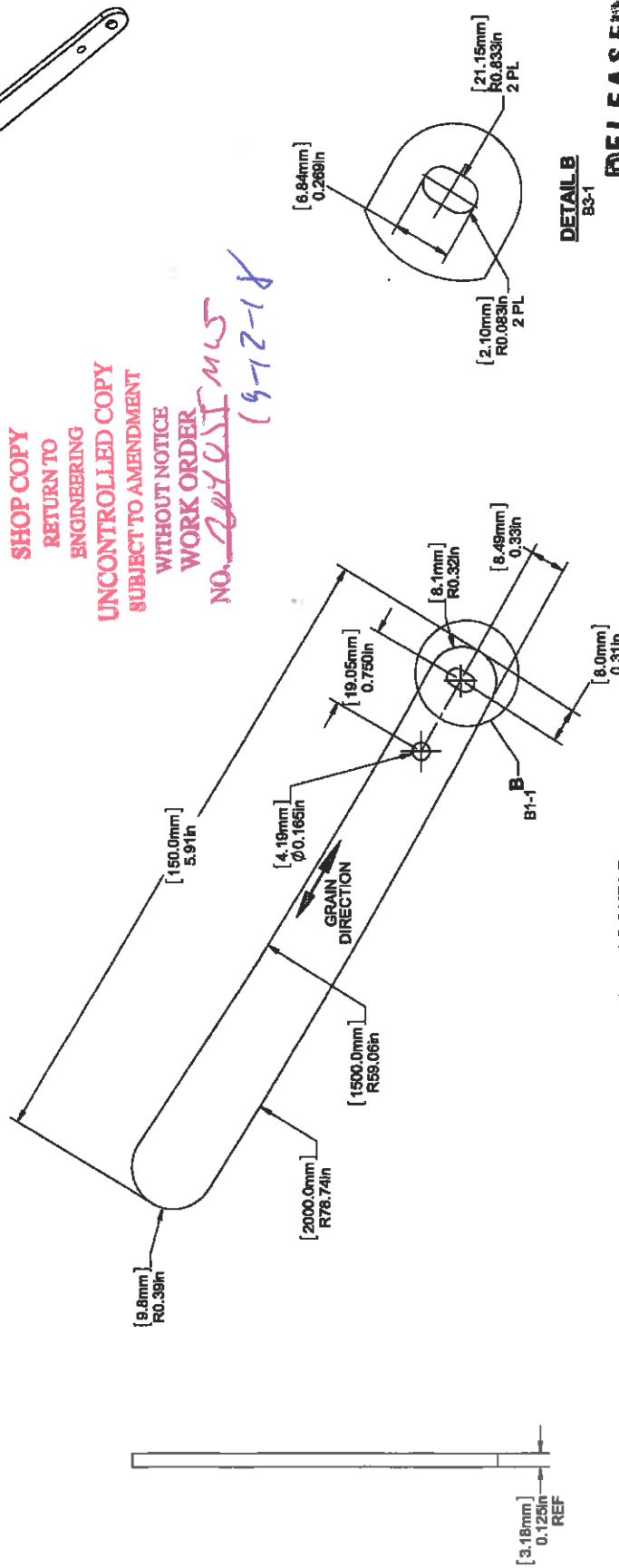
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M7075T6S.125	0	33	0

Part Specifications
Specifications could not be found.

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WITHOUT NOTICE
WORK ORDER

NO. 20401115
(9-12-18)



D4980-1 DOUBLER

DETAIL B

RELEASED
2014-06-11

C	REVISE NOTE B) (2N A4-1)	AK	14.06.06
B	REVISED D4980-1 TO ADD SLOT (2N B4-1)	AK	14.04.06
A	NEW ISSUE	DC	13.11.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DC		
DRAWN	RF		
CHECKED	HS		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS		
DATE	14.06.05		

DART AEROSPACE LTD		REV. C
HAWKESBURY, ONTARIO, CANADA		SHEET 1 OF 1
DRAWING NO. D4980		SCALE
TITLE DOUBLER		NTS
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APPROVED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO.
D4980
SHEET 1 OF 1
TITLE
DOUBLER
SCALE
NTS

- NOTES:
- 1) MATERIAL: 7075-T6 (OR T62) ALUMINUM SHEET, 0.125 in (3.18 mm) THK PER AMS-QQ-A-250/12 OR AMS 4046 OR ASTM B209 OR PER QQ-A-200/12 (REF DART SPEC M7075T6S)
 - 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P-23377J TYPE I CLASS N: 1-2 MIL MAX, AS PER QSI 005
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART PIN "D4980-1", REVISION, BATCH NUMBER AND DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 8.2
 - 7) WEIGHT: 0.05 lbs (0.02 kg)
 - 8) UNDIMENSIONED FEATURES CONTROLLED BY CAD MODEL FILE: D4980-1-c.IGES

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



DISPOSITION		DEPARTMENT/PROCESS					
Job: _____	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐		
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐		
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐		
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042) _____			
Description Work Order Deviation		Disposition					
Root Cause		FAULT CATEGORY					
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐			
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐			
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐			
Material ☐	Crimp/kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐			
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐				
Human Factors ☐	Other/Details: _____						



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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PURCHASE ORDER

POHB045491



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045491

PO Date: 1/6/20

Due Date: 1/17/20

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

2020-01-13

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	203268	646.2910	646.2900 Rev N/C	Deflector : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Anodize, Color Black / Prime As per Dwg 646.2900 Rev. N/C	Firmed	-	1/17/20	10 pcs	0 pcs	10 pcs	\$49.34/pcs	\$493.40
2	204188	RBD29905-15	RBD29905 Rev G	Center Plate (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant	Firmed X23.	-	1/17/20	23 pcs	0 pcs	23 pcs	\$5.63/pcs	\$129.49

JAN 14 2020



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PURCHASE ORDER

POHB045491



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	203825	646.3313	646.3300 Rev A	Upper Guide : Various STC's Issue P/O to ATG : Hard Anodize Color Black and Prime as per DWG 646.3300	Firmed X18	-	1/17/20	18 pcs	0 pcs	18 pcs	\$14.44/pcs	\$259.92
JAN 15 2020												
4	204055	D4980-1	D4980 REV.C	Doubler : Various STC's Issue P/O to ATG : AS PER DWG D4980 1- HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, 2- PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005 Certification of Conformity is required	Firmed X10	-	1/17/20	10 pcs	0 pcs	10 pcs	\$7.59/pcs	\$75.90
JAN 15 2020												
5	200290	RBE350A93-3302-02-5	RBE350A93-3302-02 Rev M	Extension Handle (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X12	-	1/17/20	12 pcs	0 pcs	12 pcs	\$5.63/pcs	\$67.56
JAN 14 2020												

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PURCHASE ORDER

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Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	203838	647.3912	647.3900 Rev C2	Breakaway Tip Wirestrike for Wire Strike : Various STC's Issue P/O to ATG : 1- Black Anodize as per Dwg 647.3900 2- PRIME AS PER DWG, SEE NOTE #9 Certification of Conformity is required	Firmed <i>X12</i>	-	1/17/20	12 pcs	0 pcs	12 pcs	\$12.79/pcs	\$153.48
JAN 15 2020												
7	203839	647.5710	647.5700 Rev N/C	GPS Mount : Various STC's Hard Anodize Black IAW MIL-A-8625 Type III Class 2 Cardinal 4860-50 pre-treatment primer; Prime IAW MIL-P-23377 J Type I Class N; 1-2 mil MAX Outsource process- Anodize per QSI017 4.1.10.1	Firmed <i>X8</i>	-	1/17/20	8 pcs	0 pcs	8 pcs	\$11.39/pcs	\$91.12
JAN 15 2020												
Grand Total:											\$1,270.87	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/13/20 4:21 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Number 919392

Pack List

Date: 15-Jan-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
18 ea	Part: 646.3313 Upper Guide Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot# S 236137 Job: 26715 PO: POHB045491	Rev: A Expiry Date: 05/29/2021 Line: 3	JAN 15 2020
10 ea	Part: D4980-1 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - .2 mils) per drawing. Batch/Lot# S 236137 Job: 26716 PO: POHB045491	Rev: C Expiry Date: 05/29/2021 Line: 4	JAN 15 2020 DAS 40 9-89
12 ea	Part: 647.3912 Breakaway Tip Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5-4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) (1-2 mils) Batch/Lot# S 236137 Job: 26718 PO: POHB045491	Rev: C2 ✓ Expiry Date: 05/29/2021 Line: 6	JAN 15 2020 RECEIVED JAN 15 2020 DART AEROSPACE LTD.

Made in Canada.



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760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919392

Date: 15-Jan-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
8 ea	Part: 647.5710 GPS Mount Hard Black Anodize per MIL-A-8625, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-P-23377J, Type I, Class N (Customer Supplied), .1-2 Mil max Rev: NC		
Batch/Lot#: S236137		Expiry Date: 05/29/2021	JAN 15 2020
Job: 26719		Line: 7	
PO: POHB045491			
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: JAN 15 2020 Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			